



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE117W3-3
Job Sheet 203706



Part No: RBE117W3-3

Job Qty: 4 pcs

Part Name: Frame



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/26/19

Job Tracking No:

Due Date: 1/17/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE117-W3 Rev.B IPP Rev. A 18.10.11 New issue DP Verify DD/IPP Rev. B 19.05.21 drawing revision
DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	4 pcs	1/17/20	1/17/20	0.17	2.00	Waterjet - Omax		19/12/20
110	QC 2	4 pcs	1/17/20	1/17/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		19/12/20
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Plex 11/26/19 8:36 AM Dart.lajeunesse.marie

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	Conventional Mill - 1 - B4B	4 pcs	1/17/20	0.25 0.50	Conventional Mill - 1 - B4B	JRB 12/19/19 11/12/19
					Conventional Mill - 2 - B4B	
130	QC 2	4 pcs	1/17/20	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	11/19/12/19
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	4 pcs	1/17/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	

11/26/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	DAS
			QC 8 - 52	23
			QC 8 - 23	9-89
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
150 Packaging 3-1 - Stock - B4B 4 pcs	1/17/20	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
160 QC 21 - SA	4 pcs	1/17/20	QC 21 - SA - 21	
			QC 21 - SA - 70	DAS
			QC 21 - SA - 53	21
Part Op 100 - (Waterjet - Omax) 1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u> Ream holes if required, 2-Deburr if necessary Descriptions: necessary 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (Manufacture as per dwg) Drill 0.173" by 0.40" deep hole as per DWG. 130 - (QC2- Inspect parts off machine FAI/FAIB) 140 - (QC8- Inspect parts - second check) 150 - (Identify as per dwg & Stock Location: <u>W/100</u>) 160 - (QC21- Final Inspection - Work Order Release)				
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-HRS-P-0.625	Hot Rolled Steel Plate 0.625" thk	2.1680 sf (.542 ea)	100-Waterjet - Omax - 1	5123199

Plex 11/26/19 8:36 AM Dart.lajeunesse.marie

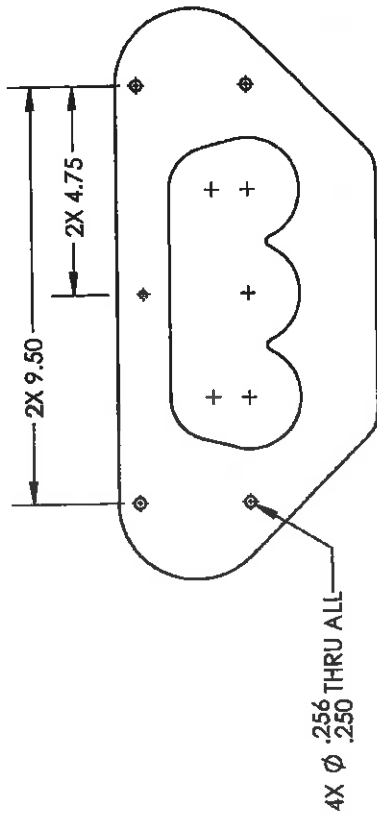
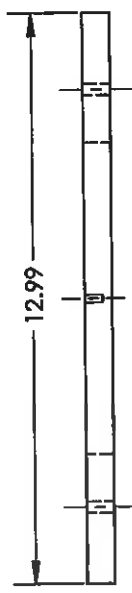
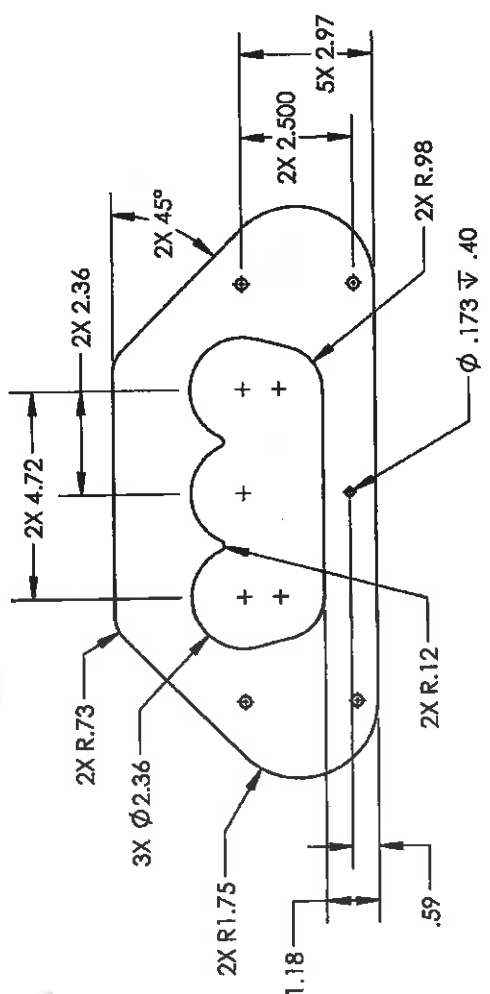
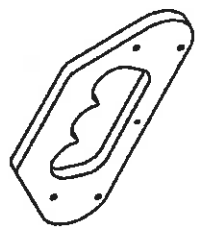
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	MT-HRS-P-0.625	2	24	0
Part Specifications				
Specifications could not be found.				

Plex 11/26/19 8:36 AM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS		
REV	ECR	DESCRIPTION

DATE	INITIAL	APPROVED



③
FRAME

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203706
1911-24



TITLE
MAIN ROTORHEAD
REMOVAL/INSTALLATION HOIST

DWG NO. RBE117-W3-3

REV B
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010
.XX ± .03
.X ± .1
ANGLES ±1°
SURFACES = 125/
1. BREAK ALL SHARP EDGES
2. DIMENSIONAL LIMITS APPLY
AFTER MACHINING
3. TOLERANCES AND TOL PER
ASME Y14.5M-2009

DRAWN BY: CLOUGH
CHECKED: DUERFELDT
OPPS APPR: ANDERSON
QA APPR: LINDSAY
APPROVED: GILBERT
USED ON MODEL
EC145

SCALE 1:4
DATE 2010-08-05
SHEET 3 OF 5



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐
Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐

Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date : _____

Sequence #: _____

QTY Affected : _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐
Material ☐ ☐ ☐
Product Improvement ☐ ☐ ☐
Process Improvement ☐ ☐ ☐
Human Factors ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
☐	☐	☐	☐
Crushing	BOM/Route	Grain Direction	Drawing
☐	☐	☐	☐
Cracks	Broken/Damage/Defect	Weld	Finish
☐	☐	☐	☐
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
☐	☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence	Misread
☐	☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up	
☐	☐	☐	

Other/Details: _____